

Split 2/2

Work Order ID 81709-2

\*81709\*

Page 1

March-19-12 8:40:52 AM

em ID: D4354-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

revision ID:

Stop

\*NS2\*

em Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012 Start Qty: 4.00

\*1\*

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4354	b
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00

0.00

\*100\*

Waterjet

Memo

0.00

LOW CNC Waterjet

1-Cut as per Dwg (D4354-1)

304 0.063

Dwg Rev: 8

Prog Rev: 1

2-Deburr if necessary

10

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

B12-4-12

(6)

B12-4-12



# Work Order ID 81709

March-19-12 8:40:52 AM

**\*81709\***

Page 2

Item ID: D4354-041

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

5/26/12

16

130

0.00

**\*130\***

Large Fab

Memo

0.00

Large Fab

1- Weld cups as per dwg  
A/R S.S. ROD BATCH: M121602

2- Apply hardfacing on wearplate as indicated on dwg  
A/R HARDCOAT 2059B BATCH: M122279

12-01-13 / CC

12-07-17 / JBL

4

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

DAS 16 17/07/18

19





**Work Order ID 81709**

March-19-12 8:40:52 AM

**\*81709\***

Item ID: D4354-041

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run

Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*150\***

QC

Memo

0.00

Quality Control

(4x)

12.7.18



160

Identify as per dwg & Stock Location **256**

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

(4x)

12/7/18 sf

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/7/18 sf

MF 12-07-28



# Picklist Print

March-19-12 8:40:55 AM

Page 1

Work Order ID: 81709

\*81709\*

Parent Item: D4354-041

\*D4354-041\*

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012

Required Date: 29/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

441.9860

0.9223

3.883368

\*\*

12-4-12

\*M304S16GA\*

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

441.986

119653

17.35

120866

73.5

120877

159.136

121070

192

121576

D4379-1

Manufactured

No

130

Each

25.0000

10

40

\*\*

\*D4379-1\*

Wearplate Cup

Location

Loc Qty

Loc Code

WA

25

79649

25

B81059

→

(172)

~~404~~

CC 12-7-17

B87518

~~11818~~

EL 12-7-17

(43)

43

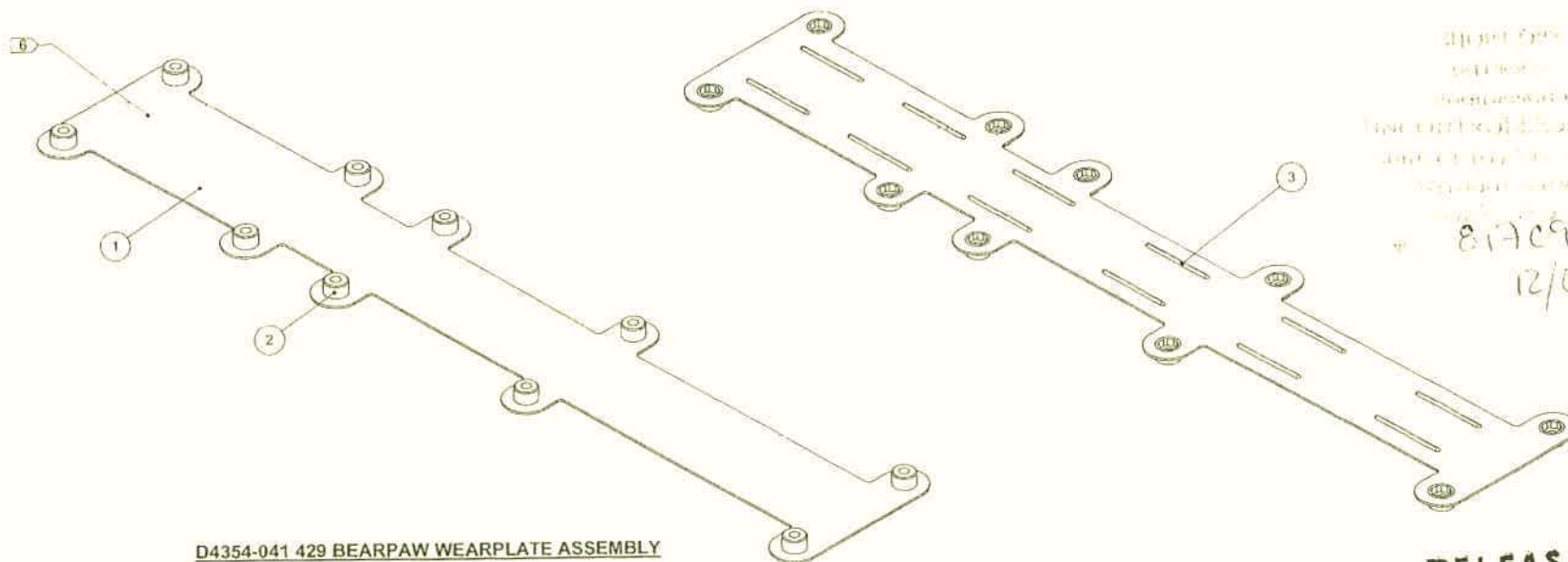








ITEM	QTY	P/N	DESCRIPTION
	X	D4354-041	429 BEARPAW WEARPLATE ASSEMBLY
1	1	D4354-1	429 BEARPAW WEARPLATE
2	10	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

81709 MJS  
12/03/19

**RELEASED**  
2011-05-23

**NOTES:**

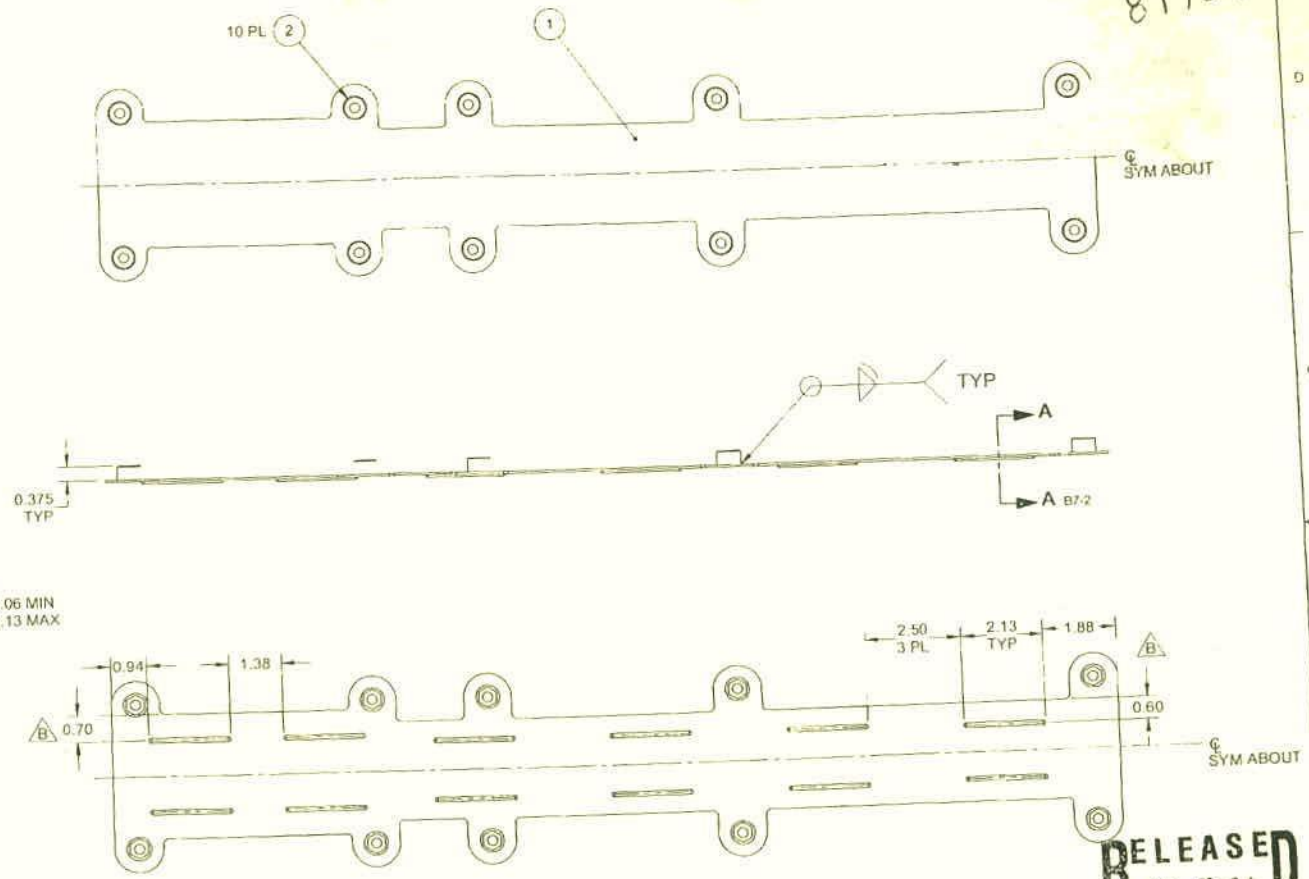
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4354-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 1.76 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	SHT 3, LIGHTENING HOLES DELETED, SHT 2 ZONE B1 & B6 HARDCOAT RELOCATED. REASON: PROTECTION OF BEARPAW		AJS	11.05.16
A	NEW ISSUE		AJS	11.03.24
REV.	DESCRIPTION		RY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4354</b> REV. B SHEET 1 OF 3 SCALE TITLE <b>429 BEARPAW WEARPLATE ASSEMBLY</b> NT COPYRIGHT © 2011 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DRAWING MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.		
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CHECKED	<i>[Signature]</i>			
MFG APPR	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR	<i>[Signature]</i>			
DATE	11.05.16			





81709



SECTION A-A C1-2  
SCALE 2X

D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

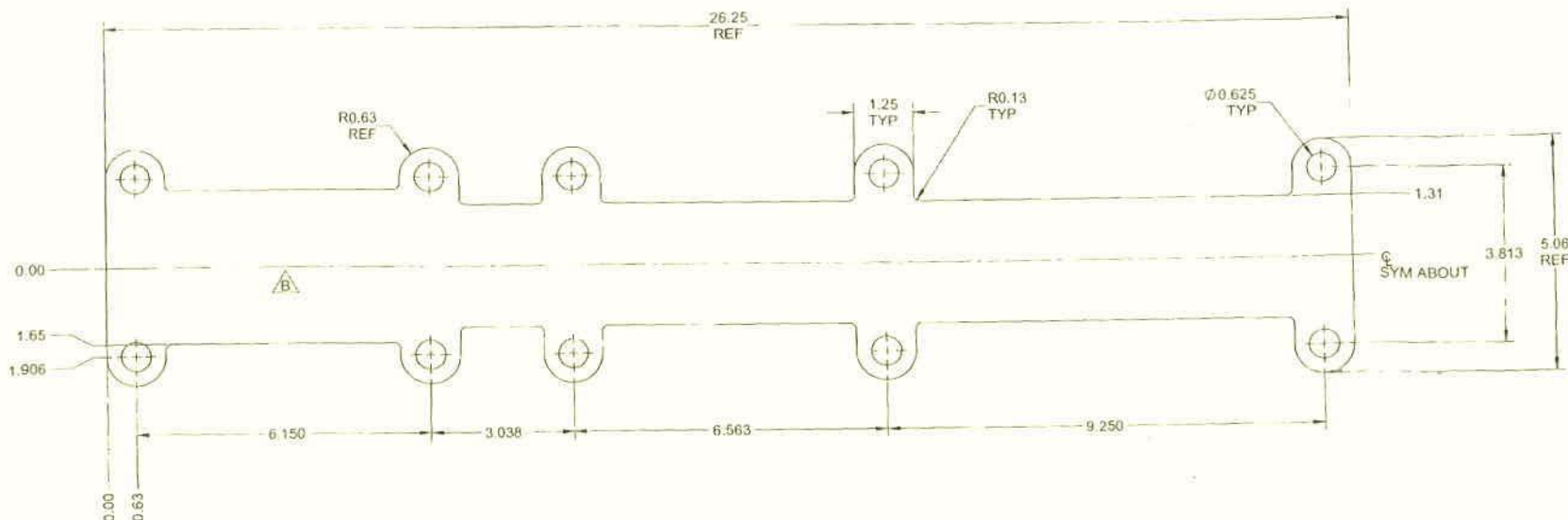
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2011-05-26

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MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 3
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DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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81709



D4354-1 429 BEARPAW WEARPLATE

RELEASED  
2011-05-21  
WMD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
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